

Claims

1. A method for making material defects in/on rod-shaped rolled material upon exiting from the finishing rolling stand, in which the flawed spots are detected in the course of the rolling process by means of ultrasound testing and/or inductive testing, said information is supplied to a computer, the defective spots are identified and stored by the computer according to the type of defect and the location, and the computer controls a marking device with the help of said data in such a way that the rod-shaped, finished material is marked in the site determined by the computer according to the respective type of defect.
2. The method according to claim 1, characterized in that the defect evaluation or defect detection and the marking command take place only at the beginning of the material test after preset period of time depending on the final rolling speed.
3. The method according to claim 2, characterized in that the detected individual defects are summed up in the course of a preset period of time and the marking command is triggered only after a defined defect relevance level has been reached.

4. The method according to any one of claims 1 to 3, characterized in that the marking takes place directly on the hot rolled material prior to the cutting to cooling bed lengths.

5. The method according to any one of claims 1 to 3, characterized in that the marking takes place after the cutting to cooling bed lengths prior to/after the cutting to the length specified by the customer.

6. The method according to claims 1 to 5, characterized in that the marking is only a virtual marking carried out and stored by the computer program.